

Work Order ID 72225 -1

Wednesday, July 20, 2011 8:59:48 AM

SPUR



Page 1

Item ID: D6101-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Billet

Start Date: 7/20/2011 Start Qty: 40.00

2011



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 40.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

CL

Date: 11/07/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D6101

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

14554

a)Description: Aluminum billet
b) 6.00" x 6.250" x 2.00" thick
c) Tolerance on length are +0.030"/-0.000"/E+/-0.008"
d) Grain direction along 6.00" length
e) Material: 7075-T7351 (QQ-A-250/12)
f)Material certification required

CL

11/07/21

40

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

11/7/2

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72225

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Page 2

Item ID: D6101-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Billet

Start Date: 7/20/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

SL 11-07-27

Memo

0.00

Ensure Material certification comply to Dwg D

130



Packaging

Packaging

Identify as per dwg & Stock Location: MAT 40

0.00

SL 11-07-27

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/27

u 11-07-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 20, 2011 8:59:45 AM

Page 1

Work Order ID: 72225



Parent Item: D6101-001



Parent Item Name: Saddle Billet


Start Date: 7/20/2011

Required Date: 8/3/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP B: ☐01.05.04☐New Issue☐EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001P  7075-T7351 2X6X6.25		Purchased	No			110	Each	0.0000	1	40			



P411/25 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

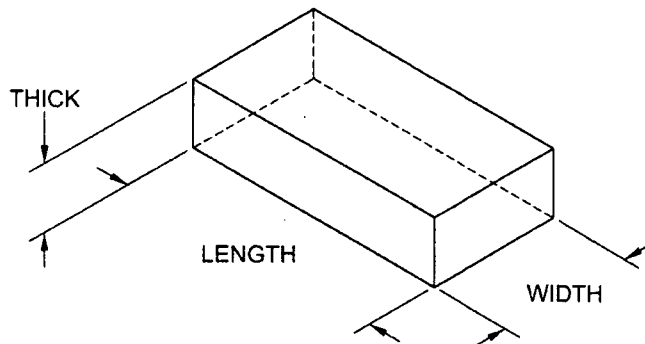
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/WP

*CY 11/07/20
W10: 72225*

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Shipment No:904357

Ship From: A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 22-JUL-2011	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 904357-2	

Shipment Details	Final Destination Branch - MON
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Order No 1554509	Line No 1	Item No 752237.MO	Description 2.0000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT 2SIDED TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12				
Purchase Order No PER RELEASE 14554		Part Number YOUR ITEM NUMBER: D6101-001		Ordered Qty 20 PCS		Invoice Qty 20 PCS	
Details		ATTN MONTREAL: HOLD FOR RELEASE					
Delivery No. 86132372	Mill	Heat Number 506772A3	Mech Id	PCS 20	Width (IN)	Length (IN)	Shipped Qty(LBS) 154.83

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.	
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.	
Reviewed by Authorized Castle Metals Representative:	Date:

SHIP TO: A M CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131
SOLD TO: AM CASTLE & CO- SOLD TO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4193016

CUSTOMER PO NUMBER: 45811	WORK PACKAGE:	CUSTOMER PART NUMBER: 6857 AMC A97075-160	SHIP RUN/LOAD: 101791/19	GOV'T CONTRACT NUMBER:		
KAISER ORDER NO: 1096361	LINE ITEM: 1	SHIP DATE: 7-MAY-2010	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: Sawed Plate
WEIGHT SHIPPED: 8224 LB	QUANTITY: 6 PCS EST.	B/L NUMBER: 2027222	GAUGE: 2.0000 IN	DIAMETER/WIDTH: 48.500 IN	LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
MMS 159/RevN

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevS
GAMPS 9101/RevB
PS 21211/RevK

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GSS16100/RevG/Amd1

Test Code: 4297

Test Results

Lot: 506772A3 Cast 314

Drop 04

Ingot 2

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	72.5 : 72.6 (500 : 501)	61.3 : 61.8 (423 : 426)	12.5 : 13.3

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	41.3 Min	41.9 Max
(MS/M) :	24.0 Min	24.3 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.17	1.4	0.04	2.4	0.20	5.5	0.04	0.01	0.01	TOT 0.05

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4193016

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

TEST NOTES

7075-T7351 plate 3.501-4.000" thick, if
ultrasonically inspected, meets requirements of CMMPO25 per
SDR CMMPO25-KaiserT-3. 7075-T7351 plate 4.001-5.000" thick,
if ultrasonically inspected, meets requirements of CMMPO25
per
SDR CMMPO25-KaiserT-2.

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

Castle Metals FP

HEAT NUMBER 506772 A3
MECHANICAL ID _____
ITEM CODE 6857
LOT NUMBER _____
PO NUMBER 45811
RECEIPT DATE 5-11-2010
SUPPLIER KAISER
SPECIFICATION _____
LCS NO
COMMENT _____
APPROVED BL

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER OFARS 225.872-1 (N), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF OFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW, ISO-9001:2000 CERTIFIED.

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poy